

Date: Tuesday, 11/6/2007 3:43:06 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT	
Job Number	35593B	Part Number	: D32782	
Estimate Number	10462	Drawing Number	: D3278 REV. C	
P.O. Number	N/A	Project Number	: N/A	
This Issue	11/6/2007	Type	: SMALL /MED FAB	
Prsht Rev.	NC	Drawing Revision	: C	
First Issue	N/A	Material	: N/A	
Previous Run	35287B	Due Date	: 11/30/2007	
Written By	: JLM 07.11.07			
Checked & Approved By				
Comment	: Est:A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"	
Comment: Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Batch: M105817 <i>DSP 07/11/15</i>			
2.0	SHEAR	SHEAR	
Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long <i>DSP 07/11/15 (40)</i>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2 <i>DSP 07/11/20 (42)</i>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DSP 07/11/20</i>			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <i>SF 07/11/20 (42)</i>			

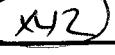
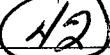
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/11/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT
Job Number: 35593B		Part Number: D32782
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>AS 07-11-20</i> 		
7.0	POWDER COATING 	POWDER COATING <i>AS 105914</i> 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <i>BR 07-11-20</i> 		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>KS</i> 
Comment: INSPECT POWDER COAT <i>AS 07-11-20</i> 		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 80</i> 		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>AS 07-11-20</i> 
Comment: FINAL INSPECTION/W/O RELEASE <i>AS 07-11-20</i>		
Job Completion 		<i>AS 07-11-21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35593B
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.099	✓			
0.359	+/-0.005	.360	✓			
0.609	+/-0.010	.615	✓			
0.250	+/-0.010	.251	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.121	✓			
2.439	+/-0.010	2.439	✓			
1.980	+/-0.010	1.980	✓			
R0.13	+/-0.030	.130	✓			
Ø0.257	+0.005/-0.000	.259	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	.400	✓			
R1.00	+/-0.030	1.00	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.128	✓			

Measured by:	J.L
Date:	04/11/19

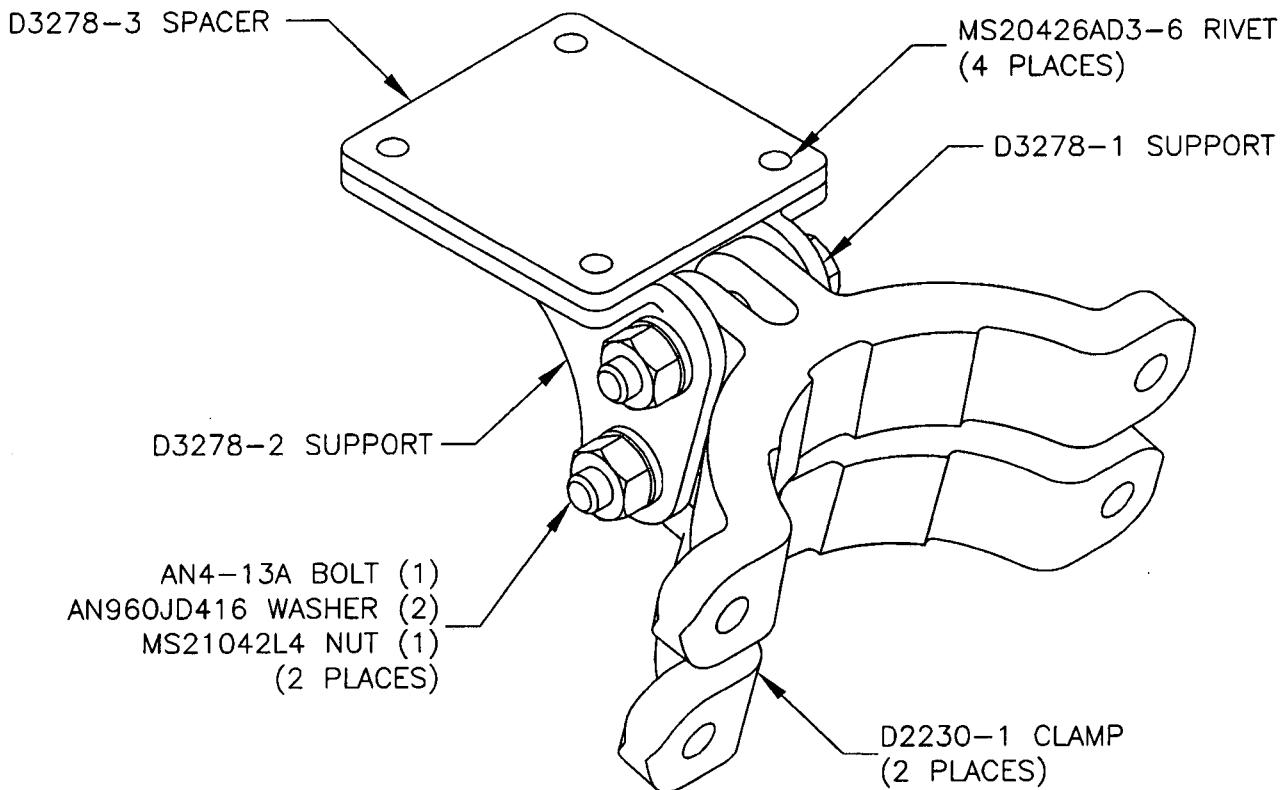
Audited by:	S.F
Date:	07/11/19

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	EZ

**DART**

DESIGN <i>91</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>JK</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07.07.24D3278-041 SUPPORT ASSEMBLY

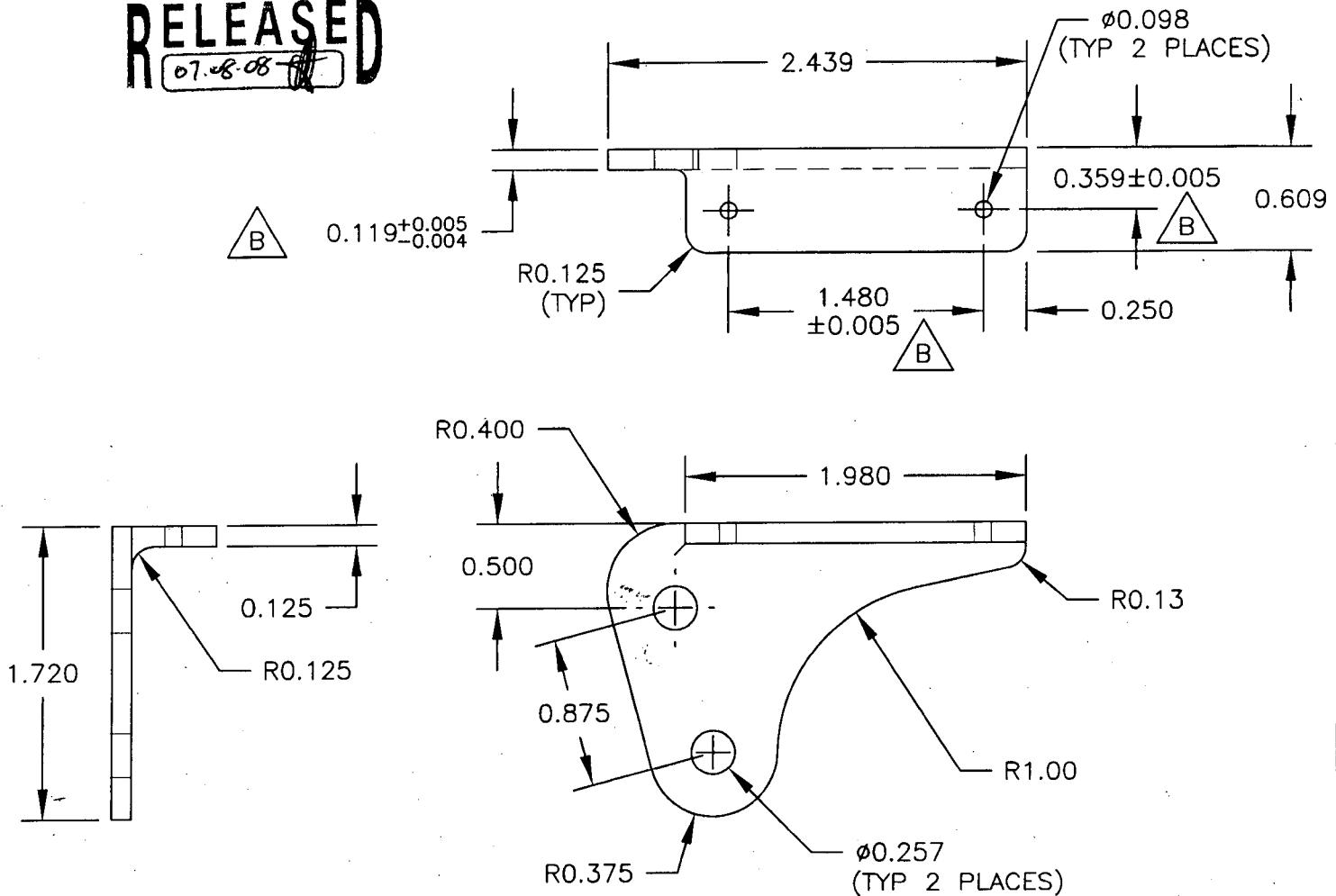
Qty	Part Number	Description	
X	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	SHOP COPY
4	AN960JD416	WASHER	RETURN TO ENGINEERING
4	MS20426AD3-6	RIVET	CONTROLLED COPY
2	MS21042L4	NUT	SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 35593B

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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

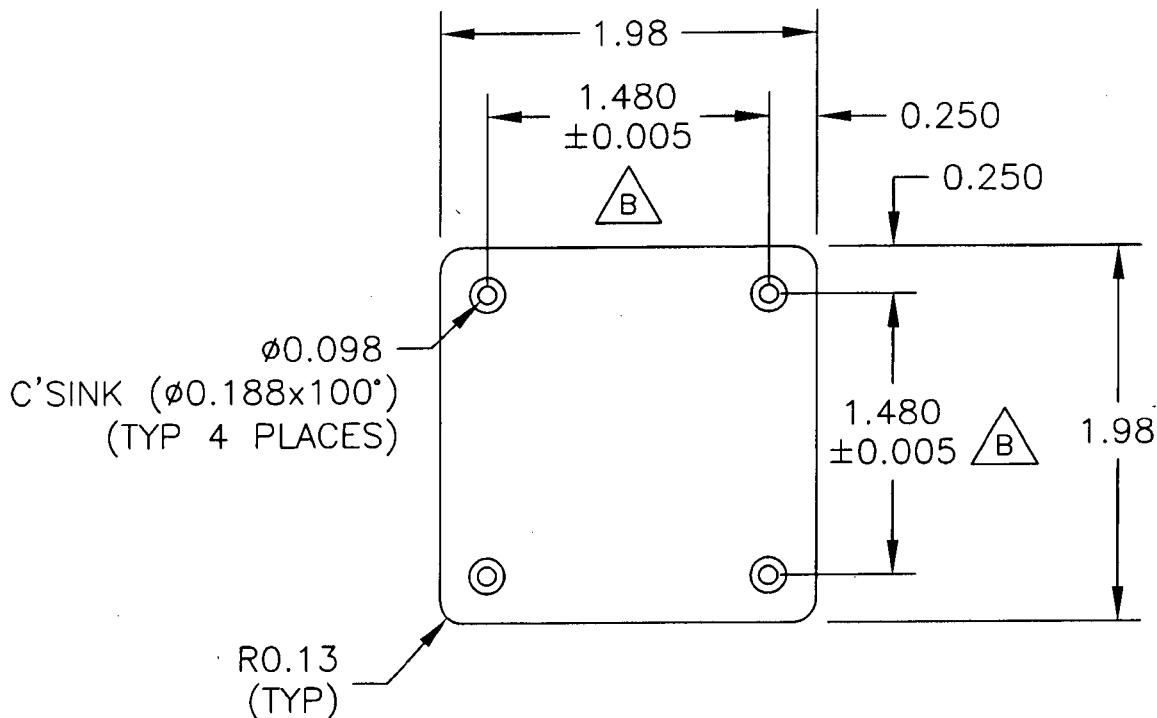
**RELEASED**  
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. *35593B*

**DART**

DESIGN <i>91</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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